



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2580-1
Job Sheet 209877



Part No: D2580-1

Job Qty: 6 pcs

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 6/12/20

Description: SIOP

Type: Stock

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD verf:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	6 pcs	6/11/20		0.00	7.69	Skidtubes - 1		DJP 20-05-20
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
101	QC 5	6 pcs	6/11/20		0.00	0.00	QC 5 - 10		DAS 03 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
110	Handfinish - 1-1 Chemical-B4B	6 pcs	6/11/20		0.00	2.00	Handfinish - 1 - 1 - B4B		BFB 20-05-20
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		



Container No: S279088



Part: D2580-1

Job No: 209877

Serial No/Batch: S279088

Revision: H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/22/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
120	QC 7	6 pcs	6/11/20	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61

DAS
03
9-89

				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
125 Skidtubes - 2 - B4B	6 pcs	6/12/20	0.00 2.48	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	DP 20.05.29
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
130 QC 5	6 pcs	6/12/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DP 20.6.1
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
140 Packaging 3-1 - Stock - B4B	6 pcs	6/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DP 20.6.1
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	6 pcs	6/12/20	0.00 0.00	QC 21 - SA - 21	DAS 21 JUN 01 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	

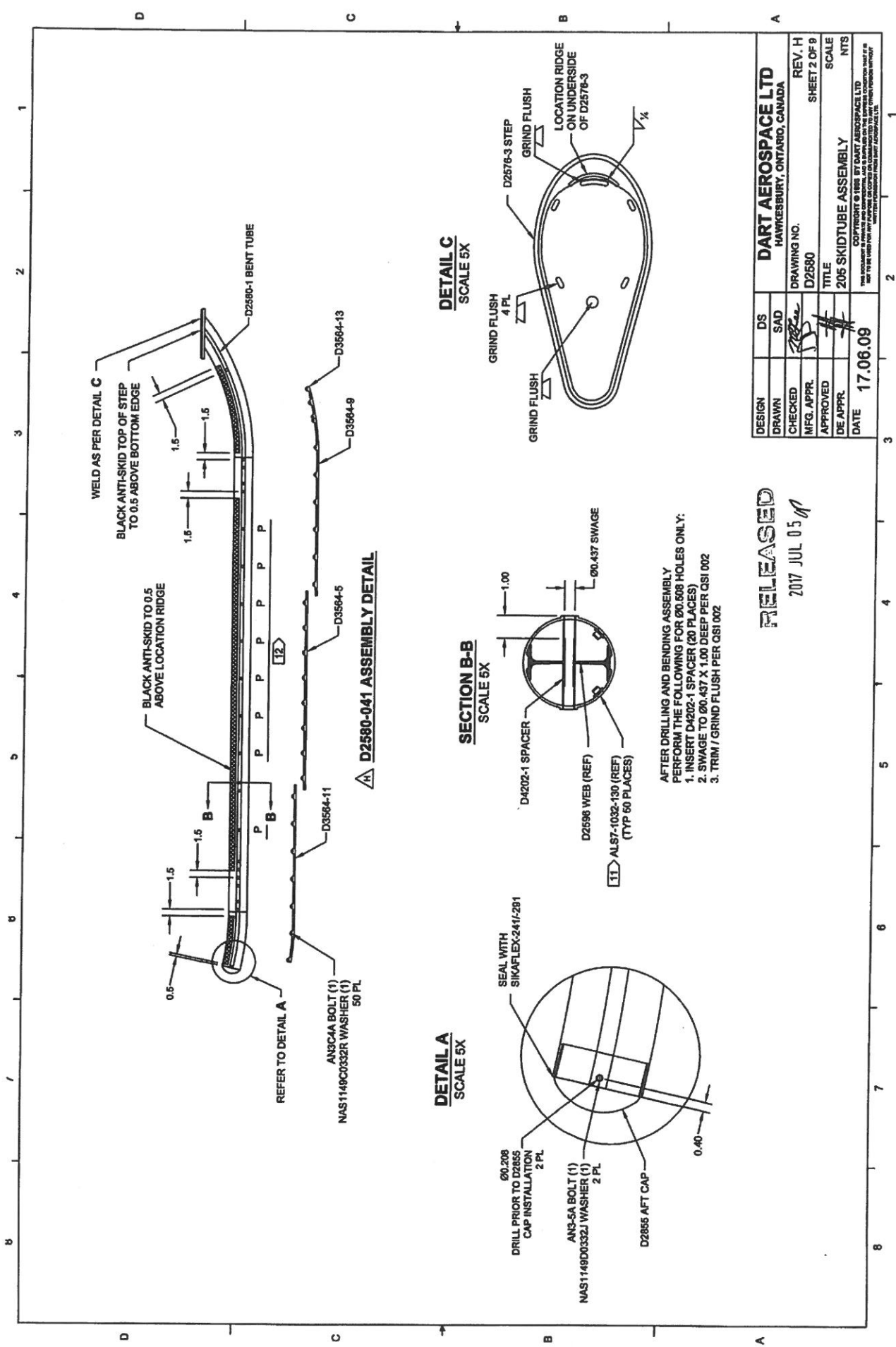
Part Op **100** - (Skidtube) 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes
 Descriptions: to 0.508" as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit
 inspection saddles on FWD & AFT saddle holes using DT9916.
101 - (QC5- Inspect part completeness to step on W/O)
110 - (Chemical Conversion Coat per QSI005 4.1)
120 - (QC7-Inspect Chemical Conversion Coat)
125 - (Skidtube) 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: S26818 Sikaflex expire 21.02.12
 date: 20.5.29 Start time and date: 3PM bond for 12hrs
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002
150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - I' Beam Tube 4"	6 pcs (1 ea)	100-Skidtubes - 1	<u>S 206078</u>
D2596	Web, 205 Skidtube	6 pcs (1 ea)	125-Skidtubes - 2 - B4B	<u>S 278340 (x4)</u> <u>S 278597 (x2)</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2500-1-190	6	44	0
125-Skidtubes - 2 - B4B	D2596	6	0	0

Part Specifications	
Specifications could not be found.	

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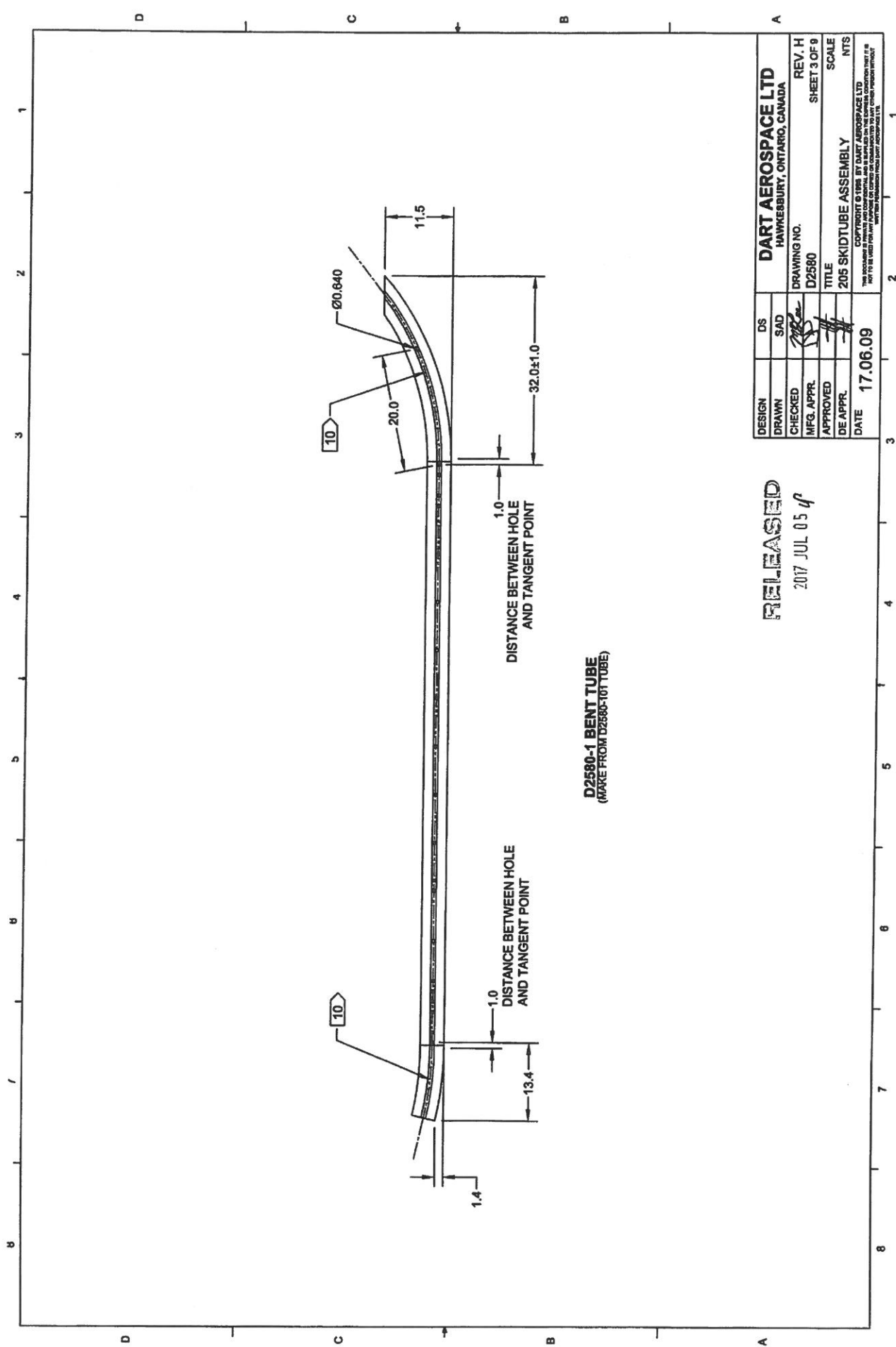


DESIGN	DS	SAD	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN			
CHECKED			
MFG. APPR			
APPROVED			
DATE	17.06.09		
DRAWING NO.	D2580		
REV. H			
SHEET 2 OF 9			
TITLE	205 SKIDTUBE ASSEMBLY		
SCALE	NTS		

RELEASED
2017 JUL 05

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
 2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
 3. TRIM / GRIND FLUSH PER QSI 002

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DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
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MFG. APPR.	10/2	D2580
APPROVED	10/2	TITLE
DE APPR.	10/2	205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTS

REV. H
SHEET 3 OF 9
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A vertical scale bar with markings from 1 to 6. The markings are evenly spaced and labeled with numbers 1, 2, 3, 4, 5, and 6 from top to bottom.



DETAIL E
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY

THE
S
A
M
E

2017 JUL 05 42

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. H SHEET 4 OF 9 TITLE SCALE NTS 205 SKIDTUBE ASSEMBLY
DRAWN	SAD	
CHECKED	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
MFG. APPR	<i>[Signature]</i>	
DE APPR	<i>[Signature]</i>	
DATE	17.06.09	THIS DOCUMENT IS OWNED BY DART AEROSPACE LTD NO PART OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD

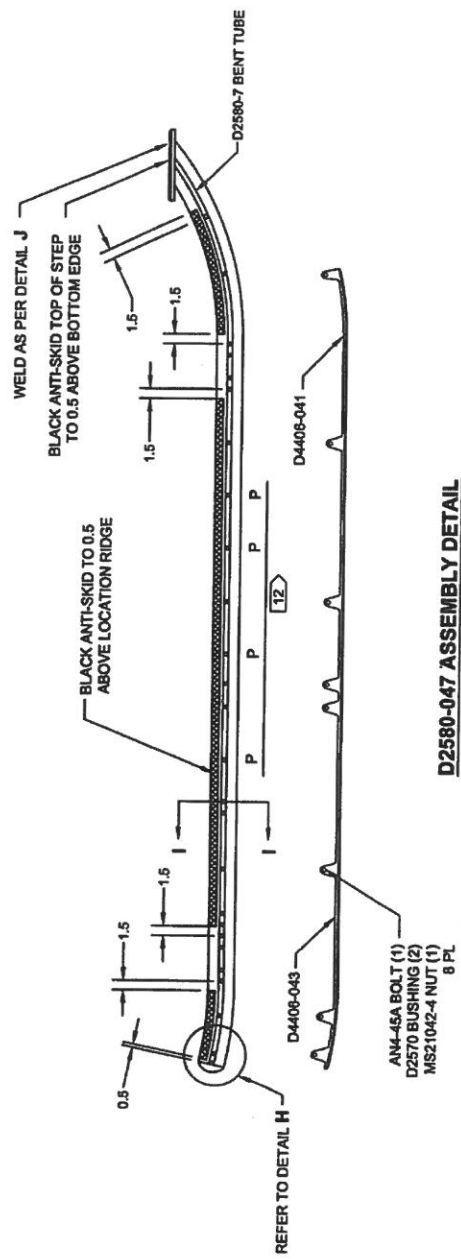


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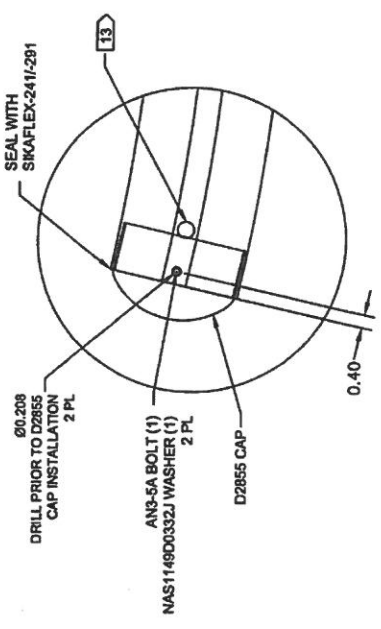
2017 JUL 05 *CP*

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 6 OF 9 SCALE NTS DART AEROSPACE LTD 205 KIDDTUBE ASSEMBLY CONTROL NO. 10000 THIS DOCUMENT IS PREPARED BY DART AEROSPACE LTD AND IS NOT TO BE USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD
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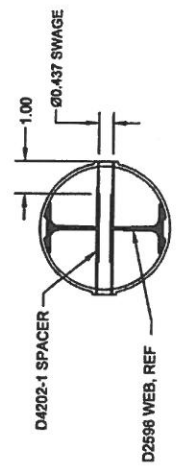
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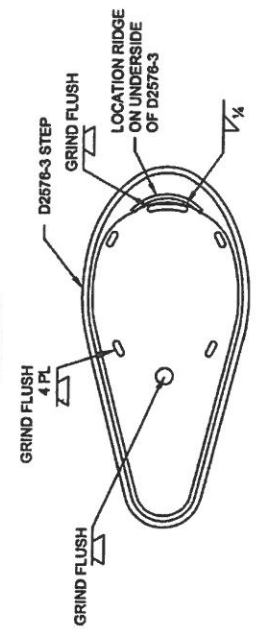
DETAIL H
SCALE 5X



SECTION I-I
SCALE 5X



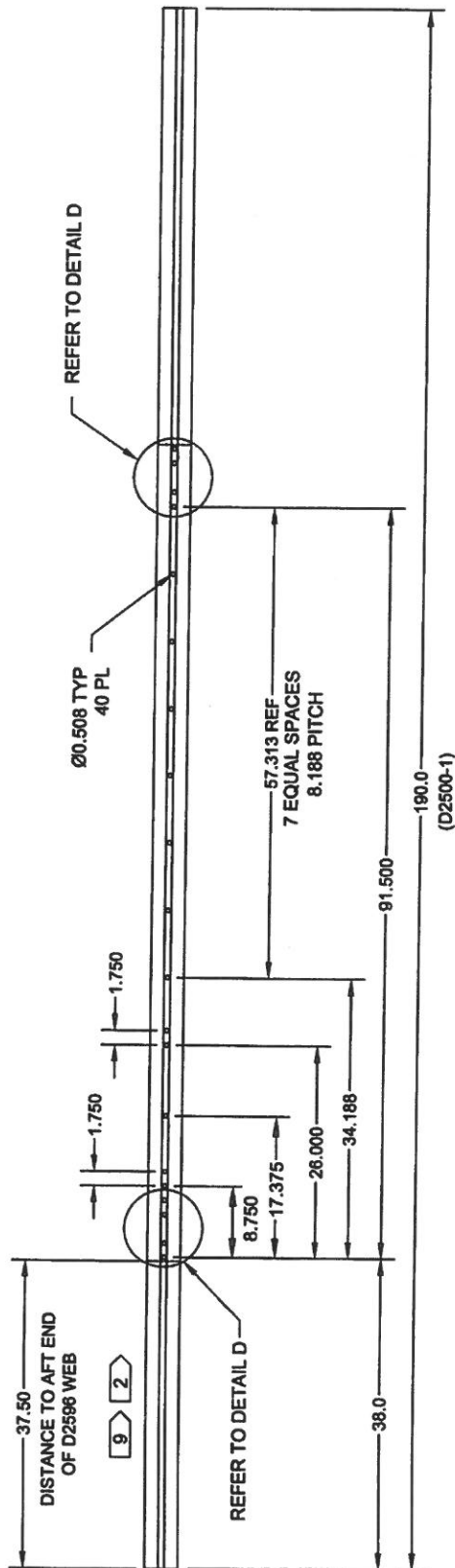
DETAIL J
SCALE 5X



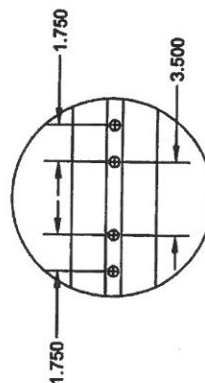
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

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DATE	17.06.09	205 SKIDTUBE ASSEMBLY NTS
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D2580-101 TUBE



DETAIL D
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DATE	17.06.09	205 SKIDTUBE ASSEMBLY NTS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation				Disposition	
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			